*QUALITY ASSURANCE PROVISIONS

C-321: SPECIFICATION:

NSN: 00-111-2993 FQ, P/N: (99207) 6004T66P02 REV. 'K",

NOMEN: Support Ring Stage 2-Nozzle

[APPLICABLE CLAUSES: T64-GE-416 Turboshaft Engine]

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (99207) 6004T66P02 Revision "K," and all details and specifications referenced therein.

- I. Quality/Inspection Requirements
 - A. MIL-I-45208 applies: Refer to contract section E.
 - B. First Article Testing applies: Refer to contract section I
 - C. Production Lot Testing applies: Refer to contract section C
 - D. Mandatory Inspection applies: Refer to contract section C.
- II. Supplemental Requirements
- A. Additionally, para. 3.1-3.5, 5.1-5.2, 6.1-6.2 of MIL-Q-9858 apply.
- B. The contractor shall include on the detailed process/operation sheets developed, all in house manufacturing processes and the identity of all manufacturing sources performing processes/ operations outside of their facilities. These sheets shall not be revised or altered after the successful completion of First Article or Production Lot Testing without approval from the basic design engineering activity via the PCO
- C. The Inspection Method Sheets which list the characteristics of each item produced under the contract shall have serial number traceability to the raw material, casting, or forging.
- D. Markings should be I/A/W MIL-STD-130 REV. "J" para. 5.3.3(a), (b), (c) and (g). Method and location shall be I/A/W drawing.
- III. Mandatory Inspection Requirements:

During production, mandatory inspection is required to be accomplished by the contractor as follows:

Encl:

Quality Assurance Requirements

- A. Level of Inspection (LOI).
- 1) Critical Characteristics: 100% inspection shall apply.
- 2) Major and Minor Characteristics LOI shall be I/A/W a sampling plan acceptable to the QAR.
- B. Critical Characteristics
- 1) General Electric Aircraft Engine Drawing (99207) 6004T66P02 Revision "K," Wall thickness, Cooling hole size and location Flange thickness. All drawing dimensions with a tolerance of 0.002 inch or less.
 - a. Zone J-5 .099/.097, dia B 17.519/17.517, dia M 17.135/17.133
 - b. Zone L-6 surfaces S-L 2.530/2.528
 - c. Zone H-6 surfaces T-L 2.274/2.272
 - d. Zone J-8 dia A 17.389/17.387
 - e. Zone B-6 View E dia P 16.519/16.517
 - f. Zone H-7 dia C 16.621/16.619
 - g. Zone H-6 dia X 16.621/16.619
 - h. Zone H-7 dia N 16.519/16.517
 - i. Zone K-3 60 tabs EQ SP in 360 with surface W to be within .001 either side of TP circumferentially
 - j. Zone H-11 Partial Section Z-Z .026-.030 dia 80 holes EQ SP and located within .010 R true position no angular relationship with other holes. Partial Section Z-Z .026-.030 60 holes EQ SP and located within .010 R of true position no angular relationship with other holes.
 - k. Zone M-8 Mark per AS478-7A3 part identification number and serial number.
 - 1. Zone K-9 .265-.267 dia 60 holes EQ SP and located within .003 R of TP.

Dwg. 6004T66 note (2) Fluorescent Penetrant, dwg. Note (3) true axis para. a,b & c, note (5) Heat Treat, note (7) gives guidance to note (3).

Verify Material B50T1233A EF (inconel) see dwg. Note (6).

VENDOR SUBSTANTIATION REQIRED

C. Major and Minor Characteristics

- 1) Shall be defined by the contractor subject to QAR concurrence, unless defined on applicable drawings and associated specifications.
- IV. Unless expressly provided for elsewhere in this Clause, equipment such as fixtures, jigs, dies, patterns, templates, mylars, special tooling, test equipment, or any other manufacturing aid required for the manufacture and/or testing of the subject item(s) will not be provided by the Government or any other source and is the sole responsibility of the contractor. The foregoing applies notwithstanding any reference to such equipment or the furnishing thereof that may be contained in any drawing or referenced specification.

-961 FIRST ARTICLE TESTS REQUIRED (CONTRACTOR TESTING)

INSN:

00-111-2993 FQ, P/N: (99207) 6004T66P02 REV."K",

NOMEN: Support Ring Stage 2-Nozzle

[APPLICABLE CLAUSES: T64-GE-416 Turboshaft Engine]

- I. First Article Inspection/Test Criteria: The tests to be performed under the First Article approval clause of the contract are:
- A. Dimensional Check 100% of finished part
- B. Form/Fit
- C. Compliance with drawing (99207) 6004T66P02 Revision "K," and specifications referenced therein.
- D. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Article(s) to be delivered hereunder shall also be subjected to those tests which will demonstrate whether the article(s) comply with contract requirements.

- *II Samples to be submitted for testing: Quantity 2 units.
- A. Waiver of First Article Testing Requirements may be granted for (99207) General Electric Aircraft Engine Group
- *III. Testing Facility:
- A. Testing shall be performed in-house by the DCMC/QAR.
- IV. Special Instructions: The contractor shall be responsible for providing necessary parts and repair of the First Article Sample(s) during testing.
- A. Sample is to be unpainted. Corrosive areas are to be coated with a light preservative.

- V. <u>NOTIFICATION OF TESTING</u>: The contractor shall notify the PCO, ACO and QAR prior to conducting First Article Tests so that the Government may witness such testing (see I-962, para. (A).
- A. The QAR shall be present to witness all First Article Tests.
- B. The following additional personnel shall witness First Article Testing.
- 1) NAVICP-PHIL Equipment Specialist
- 2) NADEP- Cherry Point, NC Quality Assurance
- 3) NADEP- Cherry Point, NC E&E Dept.
- 4) DSCR-Equipment Specialist
- VI. Test Report: The test report shall be in accordance with MIL-STD-831 and shall be submitted (2 copies) via the Cognizant CAO/QAR to the Navy Naval Inventory Control Point, (NAVICP) Phila. PA Attn. Code <u>0733</u>. The CAO/QAR shall provide comments on Form DD 1222 (2 copies) which shall be forwarded with the test report. Approval of the test report is the PCO's responsibility. Upon notification of approval/conditional approval, the ACO shall execute the DD 250 to indicate Government acceptance of the test report.
- VII. Disposition of First Article Sample(s)
- A. Sample(s) may be considered as production items under the contract provided the sample(s) can be refurbished to ready for issue (RFI) condition and provided the sample(s) have inspection approval of the cognizant QAR. Sample(s) may be shipped as production items only after all other units required under the contract have been provided and are ready for shipment.

1-962 First Article Approval (Contractor Testing)

- A. The contractor shall test 2 unit(s) of lot/item 0001 as specified in this contract. At least 45 calendar days before the beginning of First Article Tests, the contractor shall notify the contracting officer, in writing, of the time and location of the testing so that the Government may witness the tests.
- B. The contractor shall submit the First Article Test Report within 300 calendar days from the date of this contract to: NAVICP 700 Robbins Avenue Philadelphia, PA 19111 Attn: code 0733

Marked "FIRST ARTICLE TEST REPORT: Contract NO: lot/item NO.". Within 150 calendar days after the government receives the test report, the contracting officer shall notify the contractor, in writing, of the conditional approval, approval, or disapproval of the First Article. The notice of conditional approval or approval shall not relieve the contractor from complying with all requirements of the specifications and all other terms and conditions of this contract. A notice of conditional approval shall state any further action required of the contractor. A notice of disapproval shall cite reasons for the disapproval.

- C. If the First Article is disapproved, the contractor, upon government request, shall repeat any or all First Article Tests. After each request for additional tests, the contractor shall make any necessary changes, modifications, or repairs to the First Article or select another First Article for testing. All costs related to these tests are to be borne by the contractor, including any and all costs for additional tests following a disapproval. The contractor shall then conduct the tests and deliver another report to the Government under the terms and conditions and within the time specified in paragraph B above. The government reserves the right to require an equitable adjustment of the contract price for any extension of the delivery schedule, or for any additional costs to the Government related to these tests.
- D. If the contractor fails to deliver any First Article report on time, or the contracting officer disapproves any First Article, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract.

- E. Unless otherwise provided in the contract, and if the approved First Article is not consumed or destroyed in testing, the contractor may deliver the approved First Article as part of the contract quantity if it meets all contract requirements for acceptance.
- F. If the government does not act within the time specified in paragraph B or C above, the contracting officer shall, upon timely written request from the contractor, equitably adjust under the changes clause of this contract the delivery or performance dates and/or the contract price, and any other contractual term affected by the delay.
- G. Before First Article Approval, the acquisition of materials or components for, or the commencement of production of, the balance of the contract quantity is at the sole risk of the contractor. Before First Article approval, the costs thereof shall not be allocable to this contract for 1) progress payments, or 2) termination settlements if the contract is terminated for the convenience of the Government.
- H. The contractor shall provide both the First Article and the production quantity at the same facility and shall submit a certification to this effect with each First Article.

<u>C-330</u> <u>PRODUCTION LOT TESTING REQUIREMENTS</u>

[NSN: 00-111-2993 FQ, P/N: (99207) 6004T66P02 REV."K,"

NOMEN: Support Ring Stage 2-Nozzle

[APPLICABLE CLAUSES: Turboshaft Engine]

The material produced under contract shall be accepted by the cognizant CAO/QAR contingent upon the successful completion of these requirements.

- I. Production Lot Test Sampling Requirements
- A. The cognizant CAO/QAR shall select 2 item(s) at random from the first produced.
- B. Production Lot Testing to be completed during production after First Article approval.
- II. The tests to be performed under the Production Lot Sample testing provisions of the contract are:
- A. Compliance with drawing (99207) 6004T66P02 Revision "K," and specifications referenced therein.
- B. Form/Fit
- C. Dimensional Check 100% of finished part
- D. Review of documentation as provided under CDRL (DD1423) requirements.

In addition to the above tests, the Production Lot Samples(s) to be delivered hereunder shall also be subjected to those tests which will demonstrate that the sample(s) comply with contract requirements.

- III. Testing Location, Cost and Estimated Lead time
- A. All testing to be accomplished at contractors facility.

Within fifteen days of completion of Production Lot Testing, NAVAVNDEPOT, Cherry Point, NC and/or CAO/QAR shall prepare and submit two copies of their test report with conclusions and recommendations to the NAVICP-PHIL code 0733.

IV. NOTIFICATION OF TESTING:

The contractor shall notify the PCO, ACO and QAR prior to conducting Production Lot Tests so that the Government may witness such testing.

- A. The QAR <u>shall</u> be present to witness all Production Lot Tests.
- V. Inspection of Samples
- A. Upon inspection of Production Lot Sample(s) two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to NAVICP -PHIL code 0733 with duplicate copies to NAVAVNDEPOT Code 6.1.523 and to the designated test facility. The envelope shall be clearly marked. "DO NOT OPEN IN MAILROOM".
- B. Sample(s) may be considered as production items under the contract provided the sample(s) can be refurbished to Ready for Issue (RFI) condition and provided the sample(s) have inspection approval of the cognizant <u>CAO/QAR</u>. Sample(s) may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

<u>C-331</u> <u>PRODUCTION LOT SAMPLE TESTING</u> [CONTRACTOR TESTING]

A. The Production Lot Samples shall be selected at random by the cognizant government inspector. The samples shall be identified by contract number, lot number and be clearly marked as follows:

PRODUCTION LOT TEST SAMPLES NOT RFI MATERIAL DO NOT TAKE UP IN STOCK

- B. Such samples shall be tested in sufficient time prior to the delivery date of the production articles to allow a 30 day period for testing and written notification by the contracting officer of the approval or disapproval of the samples. Within 15 days of the receipt of the samples, the CAO shall notify the contracting officer, Naval Inventory Control Point, Philadelphia, PA code 0733, of the results of the testing, together with a recommendation for approval or disapproval.
- C. In the event the contractor does not receive written notification of approval or disapproval of the samples for a particular production lot within 45 days from their submission for such testing, the contract delivery schedule shall be equitably adjusted as necessary.
- D. If the contractor fails to deliver any Production Lot Samples for testing within the time or times specified, or if the contracting officer disapproves any Production Lot Samples, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract, and this contract shall be subject to termination for default.
- E. In order for a Production Lot to be acceptable, all samples representative of the lot must pass all the contract requirements. In the event a sample fails to pass such requirements, the lot will be rejected. In such event, the government may, at its option and at no additional cost to the government, (I) terminate all or any portion of this contract for default, (II) require the manufacture of a new Production Lot, or a rework of the rejected Production Lot if the means and procedures proposed by the contractor for rework are acceptable to the government, or (III) require the submission of additional samples for test. The foregoing procedures shall apply to new or reworked production lots in the same way as they did to the original Production Lot.

- F. For each additional sample or each resubmission of a modified sample which the contractor is required to submit for approval hereunder as a result of a failure of a previous sample to conform to the requirements of the specification, the contractor shall pay to the government the costs of reinspection, examination and retesting and the contractor and his sureties (if any) shall be liable for the amount of such costs.
- G. Nothing contained in the foregoing provisions of this clause, and no action of the government in accordance herewith, shall in any way prejudice the right of the government under the clause of this contract entitled Default.

CONTRACT DATA REQUIREMENTS LIST

FORM APPROVED OMB NO. 0704-0188

PUBLIC REPORTING BURDEN FOR THIS COLLECTION OF INFORMATION IS ESTIMATED TO AVERAGE 440 HOURS PER RESPONSE, INCLUDING THE TIME FOR REVIEWING INSTRUCTIONS, SEARCHING EXISTING DATA SOURCES., GATHERING AND MAINTAINING THE DATA NEEDED AND COMPLETING AND REVIEWING THE COLLECTION OF INFORMATION. SEND COMMENTS REGARDING THIS BURDEN ESTIMATE OR ANY OTHER ASPECT OF THIS COLLECTION OF INFORMATION, INCLUDING SUGGESTIONS FOR REDUCING THIS BURDEN TO DEPT. OF DEFENSE, WASHINGTON HEADQUARTERS SERVICES, DIRECTORATE FOR INFORMATION OPERATIONS AND REPORTS, 1215 JEFFERSON DAVIS HWY., SUITE 1204, ARLINGTON, VA. 22202-4302, AND TO THE OFFICE OF MANAGEMENT AND BUDJET, PAPERWORK REDUCTION PROJECT (0704-0188), WASH. DC 20503. PLEASE DO NOT RETURN YOUR FORM TO EITHER OF THESE ADDRESSES. SEND COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT / PR NO. LISTED IN BLOCK E.

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CONTRACT DATA REQUIREMENTS LIST

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FORM APPROVED OMB NO. 0704-0188

PUBLIC REPORTING BURDEN FOR THIS COLLECTION OF INFORMATION IS ESTIMATED TO AVERAGE 440 HOURS PER RESPONSE, INCLUDING THE TIME FOR REVIEWING INSTRUCTIONS, SEARCHING EXISTING DATA SOURCES, GATHERING AND MAINTAINING THE DATA NEEDED AND COMPLETING AND REVIEWING THE COLLECTION OF INFORMATION. SEND COMMENTS REGARDING THIS BURDEN ESTIMATE OR ANY OTHER ASPECT OF THIS COLLECTION OF INFORMATION, INCLUDING SUGGESTIONS FOR REDUCING THIS BURDEN TO DEPT. OF DEFENSE, REGARDING THIS BURDEN ESTIMATE OR ANY OTHER ASPECT OF THIS COLLECTION OF INFORMATION, INCLUDING SUGGESTIONS FOR REDUCING THIS BURDEN TO DEPT. OF DEFENSE, WASHINGTON HEADQUARTERS SERVICES, DIRECTORATE FOR INFORMATION OPERATIONS AND REPORTS, 1215 JEFFERSON DAVIS HWY., SUITE 1204, ARLINGTON, VA. 2220-4302, AND TO WASHINGTON HEADQUARTERS SERVICES, DIRECTORATE FOR INFORMATION OPERATIONS AND REPORTS, 1215 JEFFERSON DAVIS HWY., SUITE 1204, ARLINGTON, VA. 2220-4302, AND TO THE OFFICE OF MANAGEMENT AND BUDJET, PAPERWORK REDUCTION PROJECT (0704-0185), WASH. DC 20503, PLEASE DO NOT RETURN YOUR FORM TO EITHER OF THESE ADDRESSES. SEND COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT / PR NO. LISTED IN BLOCK E.

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INSTRUCTIONS FROM COMPLETING NEW DLA FORM 339

Part 1 - HEADER INFORMATION (Completed by initiating DLA activity)

- BLOCK 1. Indicate Case Number assigned [format = DSC + Fiscal Year (2 digits) + sequential (5 digit e.g. 00001). Note: If the Request later is returned for additional information, a suffix letter should be added to the original case number as a sixth field, e.g. 00001A.
- BLOCK 2. Transmittal date self explanatory, use mm/dd/yy format. Requests returned for additional information will recieved revised dates.
- BLOCK 3 Enter the 2-letter Secondary Inventory Control Activity (SICA) Code from the latest Total Item Record (TIR) which lists all authorized originating and submitting activities. Either check the appropriate block or 'write-in' the letter for those activities not listed on the form
- BLOCK4 Enter information on requesting office including complete office symbol, mailing address, name of individual and respective telephone and FAX numbers to facilitate later information exchange.
- BLOCK 5 Check the appropriate block for ESA response time required. Emergency items will be negotitated individually as will items requiring extended engineering effort. Examples of emergency requests include production line stoppage, MICAP aircraft, etc.
- BLOCK 6 Enter nomenclature of the item(s).
- BLOCK7 Enter National Stock Number of item involved. (Note: Limited to a single NSN per form.)
- BLOCK 8 Cite manufacturers' 5-digit CAGE code.
- BLOCK 9 Enter manufacturer's part number(s) for item.
- BLOCK 10 a. Indicate end item application for part cited in request for engineering support, e.g. F-16 Aircraft; b. Indicate narrative description of next higher assembly e.g. Landing Gear.
- Part II CRITICALITY DETERMINATION (Block 12 completed by ESA only if 'BLANK' is check in block 11).
 - BLOCK 11 Initiator will check appropriate block(YES, NO, BLANK) in item #11 to reflect what DLA records show.
- BLOCK 12 ESA will indicate here if item is critical item as defined in DLA 3200.1.
- Part III ENGINEERING SUPPORT REQUEST (To be completed by DLA initiator)
- BLOCK 13 Initiator will indicate here if engineering support (other than Criticality Determination) is required. The specific catagory of the request will be identified. Additionally, DLA initiator shall indicate their approval/disapproval recommendation in 13h.
- BLOCK 14 Enter any suplemental information or comments to fully explain/understand the request. NOTE: the TIR is being updated to include complete MMAC/SMIC code information. In the interim the initiator may annote the relevant code(s) in block 14 of the 339 form to facilitate user processing.
- BLOCK 15 Initiator shall identify any enclosures required (by number) and will make sure the such enclosures are attached to the prior to transmittal. NOTE: Eventually these enclosurers willbe transmitted electronically
- PART IV EVALUATION (To be completed by ESA when engineering support requested)
- BLOCK 16 Upon receipt of the completed DLA Form 339, the ESA shall review the content and, if insufficient to conduct an evaluation, the ESA will check block 16, complete block 17 and return to the initiator with a description in block 20 of the information that is lacking.
- BLOCK 17 ESA shall enter activity, office symbol, mailing address, point of contact, telephone and FAX information and the date that the form is received. NOTE: Once process transitions to an electronic form, the computer will automatically fill in the date received in the database.
- BLOCK 18 Evaluating ESA shall complete the appropriate section, based on the original request. For requests involving Alternate Offers, Reverse Engineering, Value Engineering, or Requests for Waiver/Deviation, the ESA shall indicate in item 18g whether the request is approved, disapproved, or conditionally approved. Conditionally approved items will provide details on the conditional approval in block 20.
- BLOCK 19 The ESA will indecate either an estimate or actual figure for manhours of engineering support provided under the request. For extended engineering efforts, ESA shall submit funding cost estimate.
- BLOCK 20 ESA shall provide any supplemental information/comments in this space, e.g. type of additional information required, details of conditional approval or reason(s) for dispproval, etc.
- BLOCK 21 ESA will identify by number any enclosures being sent back along with the completed evaluation and shall attach these to the DLA Form 339. Eventually, it is desired to have this data transferred electronically.